

Date: Friday, 12/12/2008 2:21:51 PM
User: Julie Dawson

Process Sheet

SPUR

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : MOUNTING LUG

Job Number : 44052 - 2

Estimate Number : 10428

P.O. Number :

Part Number : D32351

This Issue : 12/12/2008 S.O. No. :

Drawing Number : D3235 REV A

Prsht Rev. : NC

Project Number : N/A

First Issue : 11 Type : MACHINED PARTS

Drawing Revision : A

Previous Run : 43631

Material :

Due Date : 10/01/2009

Qty:

50 Um: Each

Written By :

Checked & Approved By : 1008-12-12

Comment : Est A 04.04.19 New Issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

D2423

Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 3.5858 f(s)

Lug Extrusion

D2423 extrusion

Batch: B43722

2.0

BAND SAW

BAND SAW



Comment: Band Saw

Cut D2423 extrusion to 0.820"

Batch: _____

cut @ 4 meters

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr

P/O: 7828

c 208/12/15

100

Machine as per D3235 REV. A

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

rec'd + inspect for damage
attached C/C to W/O

29/01/16 (60)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 09/01/16 (60) counter

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6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

G.M. 09.01.19 (60)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counters
09/01/19 x 60*

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

7:45

OVEN TEMPERATURE:

320°

FINISH TIME:

8:15

FL 09/01/20

(60)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

G.M. 09.01.20 (60)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST471

SS 09/01/23 x 60

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26 x 60

Job Completion

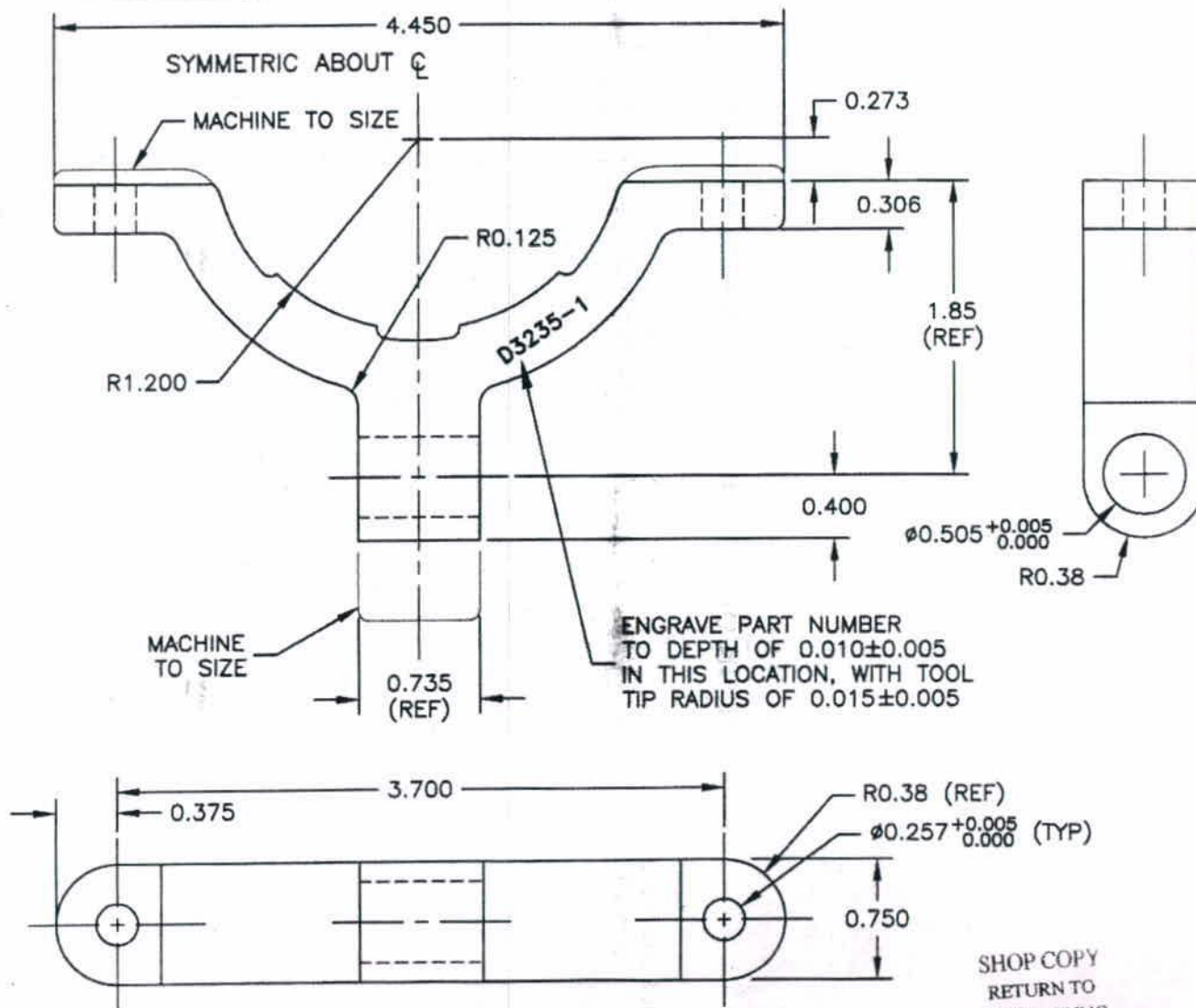


*MF
09-01-24*



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02	TITLE MOUNTING LUG		SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405 *[Signature]*



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
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WORK ORDER
NO 44052

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

60	D3235-1	Mounting Lug	7828
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MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz", written over a horizontal line.

Shigi Walz

A handwritten signature in blue ink, appearing to read "S. Walz", written in a cursive style.

Vankleek Hill, January 15, 2009